

Date: Monday, 13/04/2009 8:22:32 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 47117		
Estimate Number	: 11302		
P.O. Number	:	Part Number	: D34477
This Issue	: 13/04/2009 S.O. No. :	Drawing Number	: D3447 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 46722	Material	:
Written By	:	Due Date	: 20/04/2009 Qty: 4 Um: Each
Checked & Approved By	: <u>JLD 09.04.13</u>		
Comment	: Est.A 05.08.26 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1250	6061-T6 Round Bar 1.250
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Comment: Qty.: 0.4633 f(s)/Unit Total: 1.8530 f(s)
 6061-T6 Round Bar 1.250
 Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8)(
 M6061T6R1.250)
 Identify for D3447-7
 Batch: 1111321 2.645'

2.0	HARDINGE <u>DOOSAN</u>	HARDINGE CNC LATHE SMALL
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Comment: ~~HARDINGE CNC LATHE SMALL~~
 Turn as per Folio N/A & Dwg B67-43001 Dwg Rev: A

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
 Turn 3.750" dimension to Ø0.975
 Mill as per Dwg D3447
 Deburr

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3447-7 PAR #: N/A Fault Category: Prod Eng - Cardinal NCR: (Yes) No DQA: N Date: 05/04/22
 Resolution: PROCESS REVISED Disposition: Scrap QA: N/C Closed: N Date: 05/04/22

NCR: <u>47117</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/04/15</u>	<u>2.0</u>	<u>- 25T HOLE OVERSIZE BECAUSE A DIFFERENT DRILL WAS USED THIS TIME. HIGH PRESSURE COOLANT CAUSES DRILL TO DEFLECT UPON ENTRY AND ORDER OF OPERATIONS NOT OPTIMAL FOR ACCURATE DRILLING. (X2)</u>	<u>[Signature]</u>	<u>SCAP + REPLACE (X2). USE LOW PRESSURE COOLANT USE DRILL WITH KEENER GEOMETRY ON REVERSE ORDER OF OPERATIONS; MILL SLOT FEATURE BEFORE DRILLING</u>	<u>[Signature]</u> <u>09/04/15</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>05-04-16</u>
		<u>R.C program error.</u>		<u>- program fix.</u>				

NOTE: Date & initial all entries

Date: Monday, 13/04/2009 8:22:32 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 47117

Part Number: D34477

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-04-16 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask square section

START TIME:

2:20pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:50pm

MS 09-04-16 (24)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/17 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST440

SS 09/04/17 (24)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 (24)

Job Completion



CL 09/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

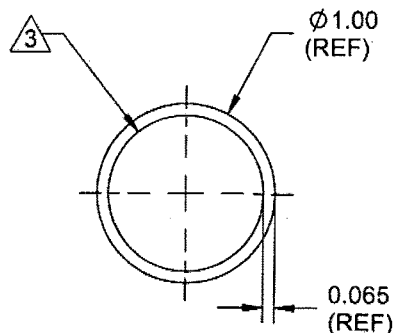
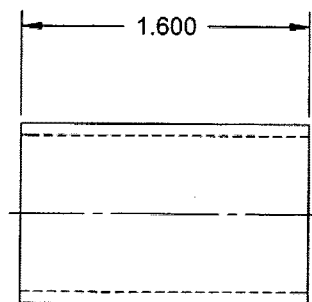
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



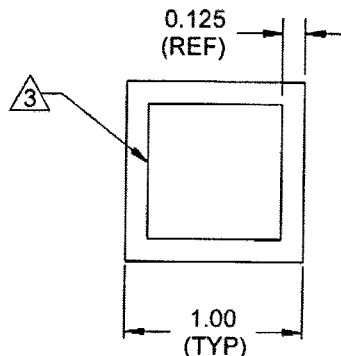
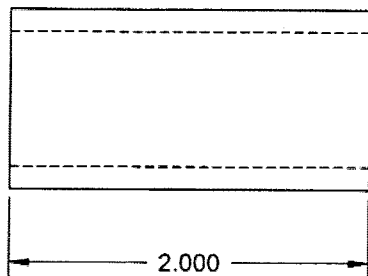
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 1 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:1
A	05.07.19	NEW ISSUE	

RELEASED
[Signature]
05/08/18



D3447-1 ROUND SPACER

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)



D3447-3 SQUARE SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

NOTES:

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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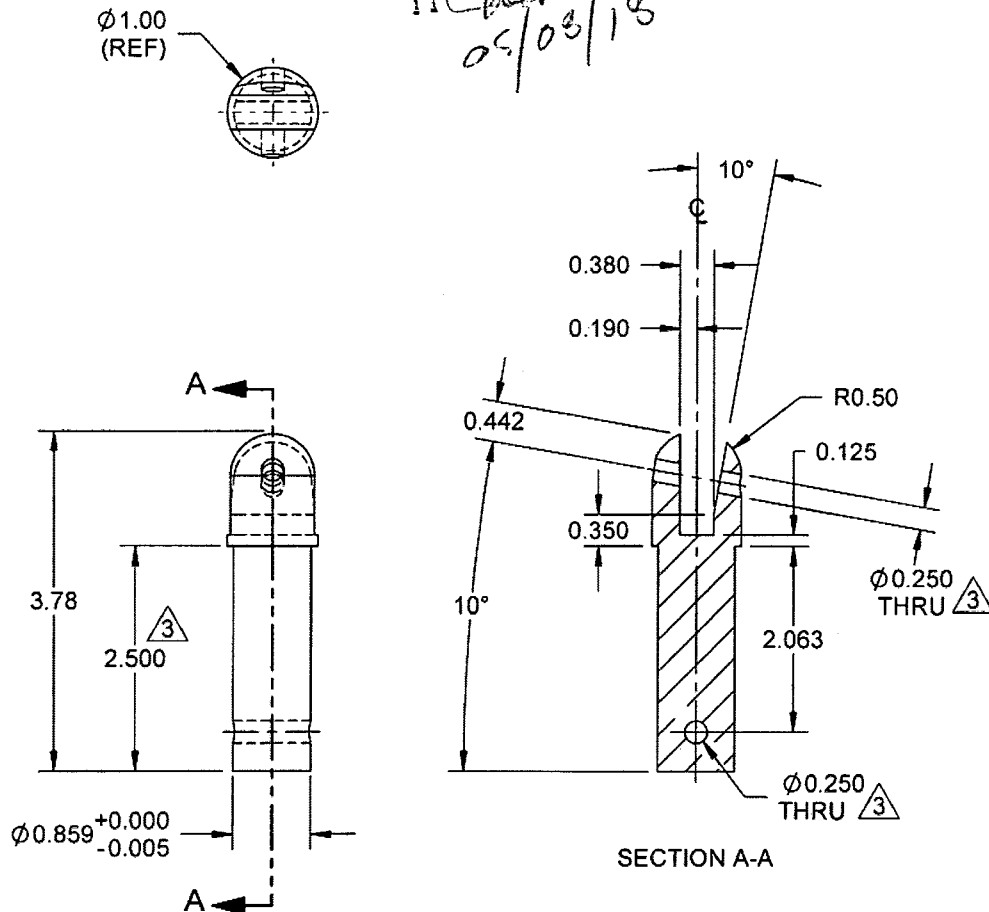
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 2 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2



D3447-5 CLEVIS
SUPERSEDES PREMIER P/N B67-43001-99

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

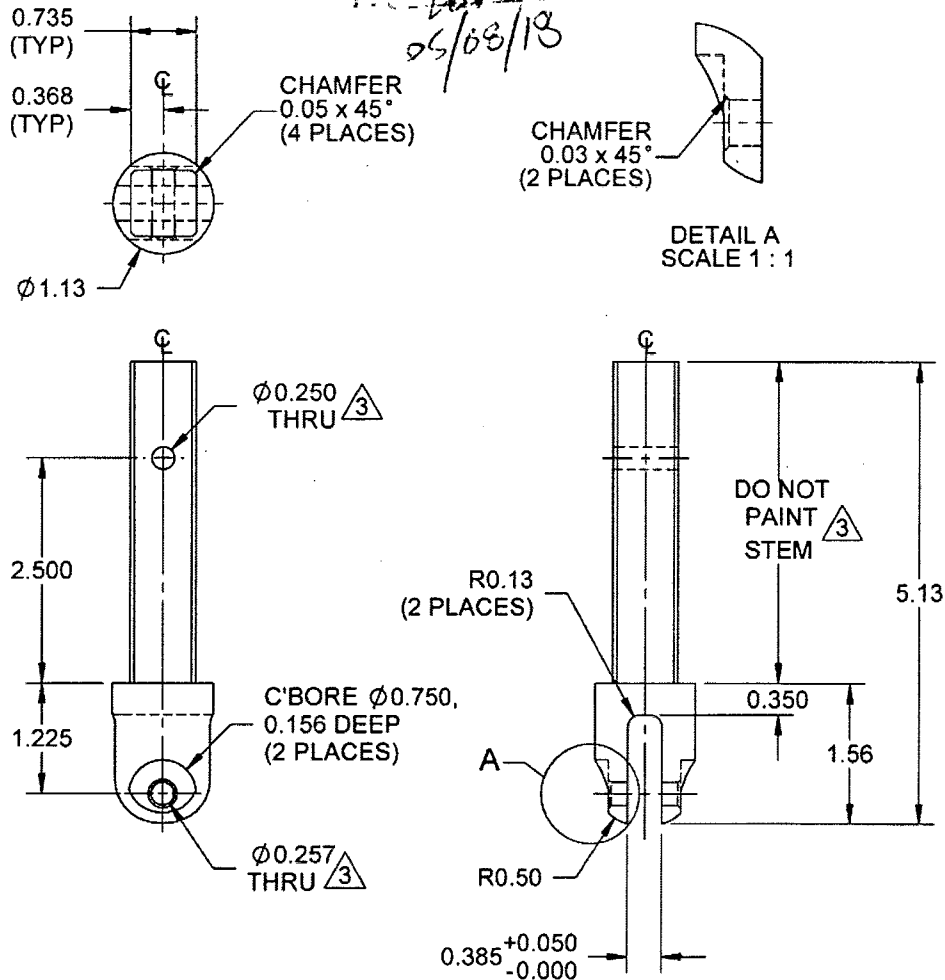
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

**D3447-7 CLEVIS****SUPERCEDES PREMIER P/N B67-43001-145/-345****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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